

Work Order ID 55104



Page 1

January 6, 2010 10:12:55 AM

Item ID: D3907-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 06/01/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

PL

Date: 10-1-06

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3907

A

100

0.00



Hardinge

0.00

Hardinge CNC Lathe Small

Memo

Machine as per Folio FA823
& Dwg D3907

Dwg Rev: A

Folio Rev: A

Deburr

10/01/12

41

110

QC2- Inspect parts off machine FA1/FA1B

0.00



QC

Memo

0.00

Quality Control

SN 10/01/12

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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January 6, 2010 10:12:55 AM

Page 2

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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
									
QC	Memo	0.00				41	18		
Quality Control									
130	Identify as per dwg & Stock Location: <i>Basket</i>	0.00							
									
Packaging	Memo	0.00				41	18		
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

60/01/13

ME 10-1-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 6, 2010 10:13:04 AM

Page 1

Work Order ID: 55104

Parent Item: D3907-1

Parent Item Name: Bushing

Start Date: 06/01/2010

Required Date: 15/01/2010

Start Qty: 40.00

Required Qty: 40.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg Part	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Requiring Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	60.0351	1.2000			



304 ROUND BAR 0.375

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	60.0850579	
112058	0.01317895	
112473	11.6003	
- 113325	48.4715789	

1.23 21 10/01/12

W/O:		WORK ORDER CHANGES					
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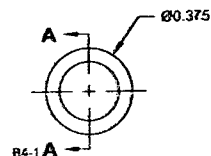
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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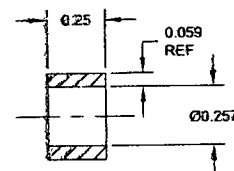
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 55104
B/10-1-06



D3907-1 BUSHING



SECTION A-A CS-1

RELEASED
Albion

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304/316

OR: AISI 304/316 STAINLESS STEEL BAR
REF DART SPEC M304/316

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART ØSI Ø16 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	09.03.11
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3907	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR		BUSHING (BASKET REPAIR)	NTS
DATE	09.03.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

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